

Work Order ID 105590

August-08-13 10:03:01 AM

ASAD Aug 15 12:58  
\*105590\*

Page 1

Item ID: D3171-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Angle Bracket

Start Date: 8/08/13 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 8/16/13 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3171

Rev A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3171

Dwg Rev: A

Prog Rev: A 2-

Deburr if necessary

304-063

28

0

Jm 13-08-09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

28

0

Jm 13-08-09

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

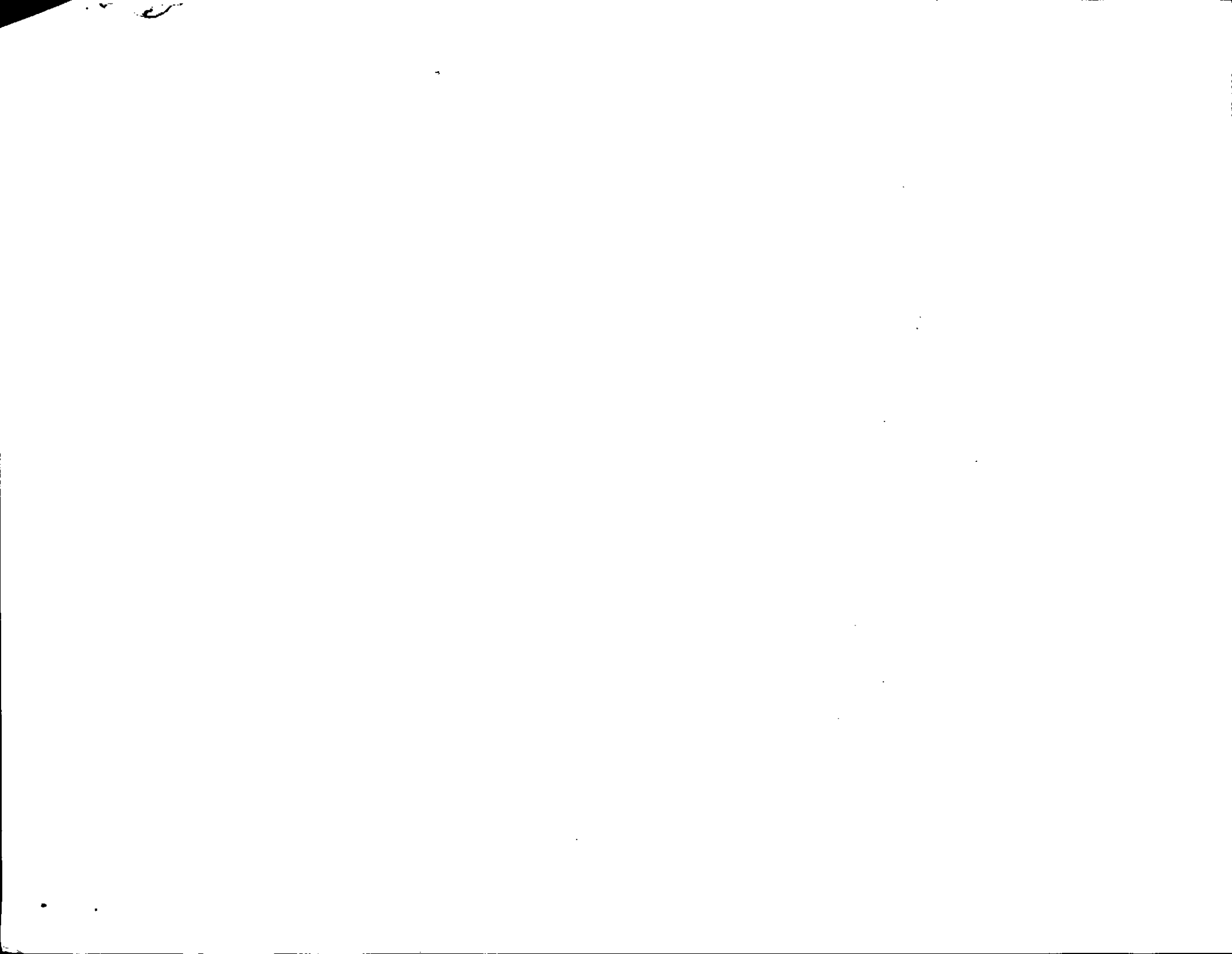
Quality Control

DAS  
16  
9-89

13/08/09

low

423



**\*105590\***

August-08-13 10:03:01 AM

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**\*20\***

**\*20\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

130

**\*130\***

### Small Fab

## Small Fab

### Small Fab

## Memo

Deburr if necessary

Set Up/  
Run Hours

0.00

0.00

**Tool ID****Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

23 SAO 13-08-12

140

**\*140\***

Brake NC

Brake NC

NC BRAKE

## Memo

Bend as per Dwg D3171Tumble

0.00

0.00

23x \_\_\_\_\_ ~~\_\_\_\_\_~~ 08/09

150

**\*150\***

QC

## Quality Control

QC5- Inspect part completeness to step on W/O

## Memo

0.00

0.00

13 & P

23

24

# Work Order ID 105590

\*105590\*

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August-08-13 10:03:01 AM

Item ID: D3171-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Angle Bracket  
 Start Date: 8/08/13 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 8/16/13 Req'd Qty: 20.00 \*20\* Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                        | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160                            | Identify as per dwg & Stock Location: <u>ST</u> | 0.00                 |         |        |              |               |               |                  |                |
| *160*                          |   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |
| 170                            | QC21- Final Inspection - Work Order Release     | 0.00                 |         |        |              |               |               |                  |                |
| *170*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

23x 11.10.13-08-12

ML5 13-08-12

ML5 13-08-12

52



# Picklist Print

August-08-13 10:03:01 AM

Page 1

Work Order ID: 105590  
Parent Item: D3171-1  
Parent Item Name: Angle Bracket

Start Date: 8/08/13  
Start Qty: 20.00  
Required Date: 8/16/13  
Required Qty: 20.00

Comments: IPP A02.11.04New IssueKJ  
IPP Rev:B 08-03-27 now on water jet DD verified by:

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty                | Qty<br>Issued | Date<br>Issued | Status     |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------------------|---------------|----------------|------------|
| M304S16GA<br>304/316 Sheet .063 |                        | Purchased     | No          |                     |                  | 100             | sf                 | 345.5802       | 0.0206      | <del>0.4336842</del><br>8.5 |               |                | J-13-08-09 |

| Location | Loc Qty     | Loc Code |
|----------|-------------|----------|
| MAT020   | 345.5801686 |          |
| 122245   | 0.1713688   |          |
| 123136   | 140.8       |          |
| 124428   | 23.61       |          |
| 125599   | 5.410631    |          |
| M126159  | 175.588169  |          |

126159





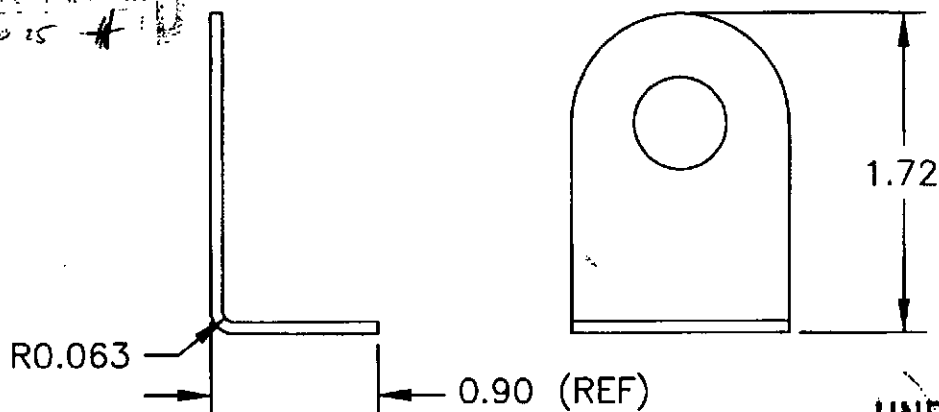






|                  |               |   |                        |
|------------------|---------------|---|------------------------|
| DESIGN<br>#      | DRAWN BY<br># | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br># | DRAWING NO.<br>D3171                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br>02.10.08 |               | TITLE<br>ANGLE                                    | SCALE<br>1:1           |
| A                | 02.10.08      | NEW ISSUE   |                        |

RELEASED  
02.10.08



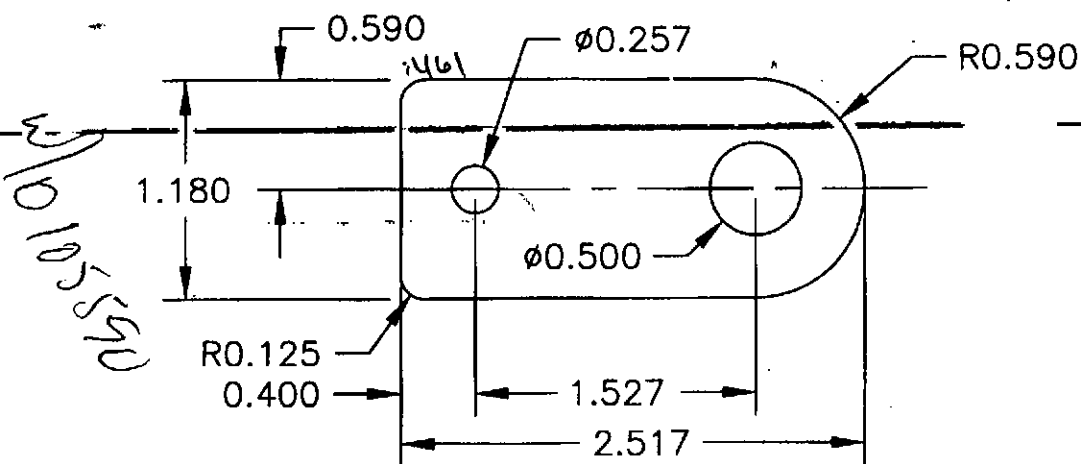
D3171-1 ANGLE

~~UNDER REVIEW~~

07.06.02 CB

adding -3

ok  
CB  
-3 not  
being  
used



D3171-1 ANGLE FLAT PATTERN

#### NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK  
PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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